Quality Control

Work Order ID 122545 Tuesday, July 22, 2014 8:39:31 AM			:	*122	2545*							Page 1
Revision ID:	D3403-1 Bushing			Accept	*N90	0040	100	ገ*	Setup	Start Stop	···IVI	S1* S2*
Start Date: 77 Required Date: 77 Reference:		Start Qty: 24.00 Req'd Qty: 24.00	*24* *24*		Cust Iten Custome						"IN	· · · · · · · · · · · · · · · · · · ·
	Process Plan:	:_ML5	Date: 14-07-23	Tooling: SPC (Y/N):		Date:			Run	Start Stop	"171	R1* R2*
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revisi	ion Nbr			.,,,							
D3403	D											
100	I	Hardinge CNC LATHE S	SMALL	0.00				DAS 02 9-89	2	- /u	(01	30 ×26
Hardinge	C 11	Memo	-	0.00				9-89	_41		- 04.	30 128
Hardinge CNC Lathe	Small	1- Turn as p Folio Rev: (\(\frac{\lambda}{2}\)	er Folio FA556 & Dwg D34 Dwg Rev:	03								
110	(QC2- Inspect parts off ma	achine FAI/FAIB	0.00				DAS		,	_	
110 QC Quality Control		Мето		0.00				9-89	31	_19	-07	-30
120	(QC8- Inspect parts - seco	nd check	0.00								
120		Memo		0.00								JL147-30

DQA:			. Date:						_				*DART
QA Closed:			Date:			WORK ORDER NON	-CC	ONFO	RMANCE / U		ork Order up	date only	AEROSPACE
QA Closed.			Date.										<u> </u>
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
	-				_	Rework]		Skid-tube	Crosstube]	Water Jet	Engineering
Part N	١o.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	•					Use-as-is	1	Thern	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR N	۷o.					Suspected Unapproved]		Large Fab	Composite		Supplier	
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Root	1		l l		Desc	ription of work order update		Initial		tion	Sign &		
Cause	_	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
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Doc/Data	\blacksquare												
Equip/Tooling													
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Material	\square												
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Offset/Setup	\vdash				*.								
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Supplier	\vdash						ĺ					į	
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Unapproved			1	<u> </u>	٠,		FΑ	ULT CA	TEGORY			<u> </u>	
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Laria	$\overline{}$	Bending			Ī	Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced
	-	Centre N	ot Concer	ntric		BOM/Route		Grain	S		Over/Under	tolerance	Set-up
	\vdash	Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred	ci	Temperature/Cure
	-	Crimp/Ki	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Ui	nqualified	Part Lost/Mi	ssing	Weld
	$\overline{}$	Cuffs		•		Contamination		Instruc	tions Incomplete/l	Unclear	Part Moved		Wrong Stock Pulled
	-	Crushing				Countersink	Г	Misali	gned/off center		Positioned V	Vrong .	
		Heat Trea				Cut Too Short		Mislab	eled		Power Loss/	Surge	Other
	—	Inspectio		Tube		Drawing		Misrea	d				
		Marks/Cl	hatter			Drill Holes		Off-set					
		Turning S	Sequence			Finish		Out of	Calibration				
		Wave/Tw	vist in Tub	е		Fit/Function		Out of	Sequence				

122545

Page 2

Insp.

Tuesday, July 22, 2014 8:39:31 AM Item ID: D3403-1 Accept *N900040100* Setup Start **Revision ID:** Stop **Item Name:** Bushing **Start Date:** 7/21/14 **Start Qty: 24.00** *24* **Cust Item ID:** Required Date: 7/21/14 Req'd Qty: 24.00 *24* **Customer:** Reference: Run Start Process Plan: Approvals: Date: Tooling: Date: Stop QC: Date: **SPC (Y/N):** Date: *NR2* Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject **Work Center ID** Description **Run Hours** Qty Code Qty Number Stamp 130 Identify as per dwg & Stock Location: 57037 0.00 DAS JUL 3 1 2014 *130* 26x 28 Packaging 0.00 Memo Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC Quality Control

Memo

0.00

u 4.07.31

DQA:		Date:										
					WORK ORDER NON-	-CC	NFO	RMANCE / UPDATE	147	l. O.ada		AEROSPACE
QA Closed:		Date:							VV	ork Order up	date only	
Work Orde	r·				DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS	
Tronk Oraci					Rework			Skid-tube Crosstube]	Water Jet	Engineering
Part No	n.				Scrap			Machining Small Fab		Pro	d. Eng. Coor.	Quality
					Use-as-is			noforming Finishing		Rec/Sto	re/Packaging	Other
NCR N	0.				Suspected Unapproved			Large Fab Composite			Supplier	
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Root	-			Desc	ription of work order update	1	nitial	Action		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
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Equip/Tooling												
Handling/Pre	╛						-					
Material \		ŀ										
Operator	_	İ										
Offset/Setup	_											
Process	_				*			·				
Supplier												
Training												
Transport	_			ŀ		1						
Unapproved	<u> </u>	Ļ	J	<u> </u>		ΕΛΙ	HT CV.	TEGORY		<u>.</u>	I	
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Lanuin	Bendin	o.			Bend		Folio/F	Program	Г	Outside Dim	ensions	Pressure/Forced
-	_	ಕ Not Conce	ntric		BOM/Route	-	Grain	108.4		Over/Under	 	Set-up
	Cracks	Not conce	THETE	-	Broken/Damage/Defect	\vdash	Hardwa	are ·		Part Incorre		Temperature/Cure
-	_	Kink/Ripple	-/Wave		Burrs	H	ł	ion Incomplete/Unqualified	\vdash	Part Lost/M	issing	Weld
<u> </u>	Cuffs	y mppic	-,	F	Contamination		•	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
<u> </u>	Crushi	ng			Countersink		4	gned/off center		Positioned V	Vrong	- -
	Heat T	_			Cut Too Short		Mislab			Power Loss/	Surge	Other
j †	_	tion Strip in	n Tube		Drawing		Misrea	d		<u> </u>		
	—	/Chatter			Drill Holes		Off-set					
	Turnin	g Sequence	<u> </u>		Finish		Out of	Calibration				
		Twist in Tu			Fit/Function		Out of	Sequence				

Picklist Print

Tuesday, July 22, 2014 8:39:31 AM

Work Order ID: 122545

122545

Parent Item:

D3403-1

D3403-1

Parent Item Name: Bushing

Start Date: 7/21/14

Required Date: 7/21/14

Page 1

Start Qty: 24.00

Required Qty: 24.00

Comments:

IPP Rev:A05.08.31New issueKJ/JLM

IPP Rev:B 06-03-07 As per Rev B JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.750 *M303R0 303 Round Bar 0.750	750*	Purchased	No		1900 Com	100	f	48.0760	0.217 **	6 DAS 02	A	14-	07.30
303 Round Bai 0.730				Locatio		Land		I C- 4.		9-89			

Location Loc Oty Loc Code MAT028 48.076 m127464 46.782 m429366 1.294

127647 x 6 128882 × 3'

DQA:		Jan.	Date:						_				"DART		
OA Closed:			Date:			WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only									
QA Closed:			Date.								<u></u>				
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT	PROCESS			
WOIK OIG	-''-					Rework			Skid-tube	Crosstube	7	Water Jet	Engineering		
Part N	lo.				٠	Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality		
	-		· · · · · · · · · · · · · · · · · · ·			Use-as-is		Therr	noforming	Finishing	Rec/Stor	e/Packaging	Other		
NCR N	١o.					Suspected Unapproved			Large Fab	Composite]	Supplier			
Root					Desc	ription of work order update	l	nitial		tion	Sign &				
Cause	\Box	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector		
Design													Ĭ		
Doc/Data															
Equip/Tooling															
Handling/Pre	\Box														
Material	Ш														
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Offset/Setup	Щ					•									
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Latiai		Bending				Bend] Folio/F	Program		Outside Dim	ensions	Pressure/Forced		
	-	Centre No	ot Concer	ntric		BOM/Route	<u> </u>	Grain	J		Over/Under	tolerance	Set-up		
	_	Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	ε ί	Temperature/Cure		
	-	Crimp/Kii	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/U	nqualified	Part Lost/Mi	ssing	Weld		
	-	Cuffs	7	•		Contamination		4	tions Incomplete/I		Part Moved		Wrong Stock Pulled		
	-	Crushing				Countersink		4	gned/off center		Positioned V	Vrong			
	-	Heat Trea				Cut Too Short		Mislab	-		Power Loss/	Surge	Other		
	-	Inspectio		Tube		Drawing		Misrea	d						
	_	Marks/Cl				Drill Holes		Off-set							
		Turning S	equence			Finish		Out of	Calibration						
		Wave/Tw	vist in Tub	oe		Fit/Function		Out of	Sequence						

DART AEROSPACE LTD	Work Order:	122545
Description: Bushing	Part Number:	D3403-1
Inspection Dwg: D3403 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
+0.010/-0.000	0.418	V		mic 3"	ET-3
+/-0.005	0.063			mic l"	21-1
+0.010/-0.000	0.25%	/		gaugepa	
+/-0.010	0.743				
+0.000/-0.002	0.424				
+/-0.010	0.0301200				
+/-0.010					
,					
	+0.010/-0.000 +/-0.005 +0.010/-0.000 +/-0.010 +0.000/-0.002 +/-0.010	Tolerance Dimension +0.010/-0.000 の.५(% +/-0.005 の.める +0.010/-0.000 の.25% +/-0.010 の.743 +0.000/-0.002 の.424 +/-0.010 の.030/ レヴ	Tolerance Dimension Accept +0.010/-0.000	Tolerance Dimension Accept Reject +0.010/-0.000	Tolerance Dimension Accept Reject Inspection +0.010/-0.000 0.416

Measured by: 9-89	Audited by:	Preliminary Approval:	
Date: 14-07-30	Date: 14-7-30	Date:	

Rev	Date	Change	Revised by	Approved
Α	06.04.21	New Issue	KJ/JLM	
В	10.11.17	Dimensions updated per Dwg Rev C	KJ IN	11
С	12.07.31	Dwg Rev updated	KJ ()	4/

